



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2873-043
Job Sheet 180274



Part No: D2873-043

Job Qty: 50 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Machining-1		mmc 18/07/10
100	Bandsaw	50 pcs	7/31/18	7/31/18	0.00	0.24	Bandsaw1		11
110	CNC Vertical Machining	50 pcs	7/31/18	7/31/18	0.04	13.19	HAAS1-2		11
120	QC	50 pcs	7/31/18	7/31/18	0.00	0.00	QC2 Machining-1		11
130	QC	50 pcs	7/31/18	7/31/18	0.00	0.00	QC8 Machining-1		11
150	QC	50 pcs	7/31/18	7/31/18	0.00	0.00	QC5 N/A		11
160	HandFinish	50 pcs	7/31/18	7/31/18	0.00	0.63	HandFinish1		SA 18-07-17
170	QC	50 pcs	7/31/18	7/31/18	0.00	0.00	QC7-1		11
180	Small Fab	50 pcs	7/31/18	7/31/18	0.00	1.70	Small Fab-2		11
190	QC	50 pcs	7/31/18	7/31/18	0.00	0.00	QC5		11
200	Packaging	50 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3-1 LG050		11
210	QC21-SA	50 Ea	7/31/18	7/31/18	0.00	0.00	QC21		11

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev ____ Folio Rev ____

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043

200 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	15.4150 ft (.3083 ea)	90-Start up Operation	
MS20426AD4-6	Rivet	300 Ea (6 ea)	180-Small Fab	5076836 140x 5093088 100
MS21075L5	Nut Plate	150 Ea (3 ea)	180-Small Fab	5071832 120x 5039328 30x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X1.000	15	60	0
180-Small Fab	MS20426AD4-6	300	928	0
	MS21075L5	150	444	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 180274
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	/			
2.000	+/-0.010	1.999	/			
0.750	+/-0.010	0.750	/			
1.000	+/-0.010	0.999	/			
0.250	+/-0.010	0.249	/			
1.000	+/-0.010	1.001	/			
2.000	+/-0.010	2.000	/			
3.000	+/-0.010	2.999	/			
Ø0.128	+0.005/-0.001	0.1285	/			
0.359	+/-0.010	0.359	/			
Ø0.316	+0.006/-0.001	0.316	/			
1.000	+/-0.010	1.000	/			
0.250	+/-0.010	0.250	/			
0.061	+/-0.010	0.060	/			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 0.125				

Measured by: [Signature]	Audited by:	Prototype Approval:	N/A
Date: 18/07/10	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	[Signature]

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only

AGAINST DEPARTMENT/PROCESS

Product	Supplier	Material	Quantity	Unit Price	Total Price
Engine	Engineer	Engine	1	100	100
Water Jet	Water Jet	Water Jet	1	100	100
Prod. Eng. Coord.	Prod. Eng. Coord.	Prod. Eng. Coord.	1	100	100
Rec/Store/Packaging	Rec/Store/Packaging	Rec/Store/Packaging	1	100	100
Supplier	Supplier	Supplier	1	100	100
Cross tube	Cross tube	Cross tube	1	100	100
Small Fab	Small Fab	Small Fab	1	100	100
Finishing	Finishing	Finishing	1	100	100
Composite	Composite	Composite	1	100	100

ctive :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator

Container No: S090584



Part: D2873-043

Job No: 180274

Serial No/Batch: S090584

Revision:

Inspector

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/10/18

FAULT CATEGORY

Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong
Bending		Set-up		Folio/Program		Outside Dimensions
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance
Cracks		Broken/Damage/Defect		Weld		Part Incorrect
Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing
Cuffs		Contamination		Out of Sequence		Part Moved
Crushing		Countersink		Off-set		Drawing
Heat Treat		Cut Too Short		Mislabeled		Finish
Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread
Marks/Chatter		Drill Holes		Misaligned/off center		Turning Sequence

Root Cause

Environment	No Re-verification
Design	Operator
Doc/Data	Offset/Setup
Equip/Tooling	Supplier
Handling/Pre	Training
Material	Use for Testing
Internal Transport	Poor Information
Tribal Knowledge	Rushing
LOA	Product Improvement
Substation	Process Improvement
Past Expiry Date	Manufacturing Process
Misidentified	Past Due

OTHER: